Work Order January-07-14 3:0			*110	1821*							Page 1	
Revision ID: Item Name: W	/07/14 Start Qty: 80.00 /07/14 Req'd Qty: 80.00		* 84 X	*N900 Cust Item 1 Customer:		100)* s		tart Stop	*N!	S1* S2*	=
Reference:					ate:	_	F	Run S	tart	*NI	R1*	
	Process Plan: MLJ QC:		SPC (Y/N):		ate:			S	Stop		R2*	
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rejec Qty		Reject Number	Insp. Stamp	
Draw Nbr	Revision Nbr											
D3537	Rev C					,						
*100 *100* Waterjet FLOW CNC Waterjet	FLOW WATER JET Memo 1-Cut as pe if necessary	er Dwg D3537Dwg Rev: _	0.00 0.00 	2-Deburr			84				Ae 14.01.	2
110 *11 0 *	QC2- Inspect parts off r	nachine FAI/FAIB	0.00				84	O			Ae	
QC Quality Control	Мето		0.00								<u>Ae</u> 14.01.	<i>),</i>
120 *1 <i>2</i> 0*	QC8- Inspect parts - sec	cond check	0.00 DAS			(c	xsy					
QC QC	Memo		16 0.00 9-89	14/01/5)		(<u> </u>				

Quality Control

DQA:		Date:										TRAC
QA Closed:		Date:			WORK ORDER NON-	-CO	NFO	RMANCE / UPDATE	W	ork Order up	odate only	AEROSPACE
Work Orde	or:				DISPOSITION			AGAINST	DE	PARTMENT,	/PROCESS	
Part N	lo				Rework Scrap Use-as-is Suspected Unapproved		I Therm	Skid-tube Crosstube Machining Small Fab noforming Finishing Large Fab Composite		1	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root				Desc	ription of work order update	lr	nitial	Action		Sign &		
Cause	Date	Step	Qty		or non-conformance	Chi	ief Eng	Description		Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre				and the second s					A. W. 4			
Material Operator Offset/Setup								, •				
Process Supplier Training Transport Unapproved	- - - - -						-		. *			
			•			FAU	JLT CA1	EGORY				
Landii	Bending Centre N	ot Conce	ntric		General Bend BOM/Route Broken/Damage/Defect			rogram		Outside Dim Over/Under Part Incorre	tolerance	Pressure/Forced Set-up Temperature/Cure
	Crimp/Kii Cuffs Crushing Heat Trea		e/Wave		Burrs Contamination Countersink Cut Too Short		Inspecti Instruct	on Incomplete/Unqualified ions Incomplete/Unclear ined/off center		Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ssing	Weld Wrong Stock Pulled Other
	Inspection Marks/Cl Turning S Wave/Tw	n Strip in natter Sequence	Tube		Drawing Drill Holes Finish Fit/Function		Misread Off-set Out of 0					

Work Order January-07-14 3:0		0821			*110	1821*							Page 2
Revision ID:	3537-1 'earpad				Accept	*N900	040	100)*	Setup	Start Stop		S1* S2*
	07/14	Start Qty: 80.00 Req'd Qty: 80.00		*80* *80*		Cust Item I Customer:	D:			_			
* *		nn:	Date:_ Date:_		Tooling: SPC (Y/N):		ate:			Run	Start Stop	^I <i>V</i> I	R1* R2*
Sequence ID/ Work Center ID	¥ 1000) = =	Operation Description			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Rej Qty		Reject Number	Insp. Stamp
130 *120* Brake NC Brake NC		NC BRAKE Memo 1-Form as Identify as		537 on CNC bra	0.00 0.00 ke using Jigs DT 8261 a	and DT 8326.2-	DAS 30 9-89		94				/4lou
140 *1 4 1 * Large Fab Large Fab		Large Fab Memo Oty De	scription	Batch	0.00 0.00 AA/R 2059B Har	dcoat			_84	<u> </u>		lcc,	<u>/4-2-4</u>

150

QC10- Inspect visual per QSI004- ground welds

0.00

150

Memo

0.00

9-89

DAS

9

Quality Control

DQA:			Date:												
OA Clasadi			Data			WORK ORDER NON-	-CC	ONFO	RMANCE / L		VA/	ork Ordor ur	adata anki - [AEROSPACE
QA Closed:			Date:		1						VV	ork Order up	date only		
Work Orde	er:					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
	•				_	Rework	1		Skid-tube	Crosstube]	Water Jet		Engineering
Part N	lo.					Scrap			Machining	Small Fab		Pro	d. Eng. Coor.		Quality
	•					Use-as-is			noforming	Finishing		1	re/Packaging		Other
NCR N	١o.					Suspected Unapproved			Large Fab	Composite	-	1	Supplier		
					_					•		•	•		
Root					Desci	ription of work order update	I	nitial	Ad	ction		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	cription		Date	Verification	n	QC Inspector
Design															
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Equip/Tooling															
Handling/Pre															
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Operator															
Offset/Setup							l								
Process							l		i						
Supplier															
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Transport							ŀ								
Unapproved															· · · · · · · · · · · · · · · · · · ·
							FAI	ULT CA	TEGORY	· · · · · · · · · · · · · · · · · · ·					
Landi	ng (General						-			•
		Bending			· L	Bend	L	1	Program			Outside Dim			Pressure/Forced
		Centre No	ot Concer	ntric	-	BOM/Route		Grain			L	Over/Under	tolerance		Set-up
		Cracks			<u> </u>	Broken/Damage/Defect		Hardwa	are		L	Part Incorre	cí		Temperature/Cure
		Crimp/Kir	ık/Ripple	/Wave		Burrs		Inspect	ion Incomplete/U	Unqualified	_	Part Lost/Mi	- 1		Weld
5		Cuffs				Contamination		Instruct	tions Incomplete,	/Unclear		Part Moved			Wrong Stock Pulled
		Crushing				Countersink		Misalig	gned/off center	r		Positioned V	Vrong		•
	<u> </u>	Heat Trea	it			Cut Too Short	L	Mislabe	eled			Power Loss/	Surge		Other
	<u> </u>	Inspection	n Strip in	Tube		Drawing		Misrea	d						
	_	Marks/Ch				Drill Holes		Off-set							
	L	Turning S	equence			Finish		Out of	Calibration						
		Wave/Tw	ist in Tub	oe e		Fit/Function		Out of	Sequence						

Work	Order	ID	110821
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OC

Quality Control

110821

Page 3 January-07-14 3:08:49 PM Accept Item ID: D3537-1 *N900040100* Setup Start **Revision ID:** Stop **Item Name:** Wearpad *80* **Start Date:** 1/07/14 **Start Oty: 80.00 Cust Item ID:** Required Date: 1/07/14 Rea'd Otv: 80.00 *80* **Customer:** Reference: Run Start Process Plan: Date: **Tooling: Approvals:** Date: Stop Date: Date: QC: SPC (Y/N): Reject Sequence ID/ **Operation** Set Up/ Tool ID Tool # Plan Accept Reject Insp. **Work Center ID Description** Stamp **Run Hours** Code Qty **Qty** Number 160 QC5- Inspect part completeness to step on W/O 0.00 DAS *160* 14.02.0H QC 0.00 Memo 9-89 Quality Control 170 Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 0.00 84 \$ 14-2-5. 38\$ M 125078 *170* Powdercoat 0.00 Memo **Powder Coating** 180 QC3- Inspect Part Finish 0.00 *120*

0.00

Memo

DQA:			Date:											•	TRAGE
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFOI	RMANCE / L		W	ork Order up	odate only	\neg	AEROSPACE
Work Orde	ŗ.					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
Part N	o					Rework Scrap Use-as-is Suspected Unapproved			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		4	Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root					Desc	ription of work order update	ı	nitial	Ad	ction		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	cription		Date	Verification		QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved					•										
							FA	ULT CA	regory						
Landir		Bending Centre No Cracks Crimp/Kir Cuffs	nk/Ripple			General Bend BOM/Route Broken/Damage/Defect Burrs Contamination		Grain Hardwa Inspect Instruct	ion Incomplete/l ions Incomplete,	/Unclear		Outside Dim Over/Under Part Incorre Part Lost/M Part Moved	tolerance ci issing		Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled
		Crushing Heat Trea Inspectio	at	Tube		Countersink Cut Too Short Drawing		Misalig Mislabe Misrea		•		Positioned V Power Loss/			Other
		Marks/Ch	natter			Drill Holes		Off-set							
		Turning S Wave/Tw			F	Finish Fit/Function		4	Calibration Sequence						
1 1		ANGAGLIM	rist ni TUL) C		prigranicaon	1	Jour or .	Jequence						

Work Orde January-07-14 3		0821		*110	1821*							Page 4
Revision ID:	D3537-1 Wearpad			Accept	*N900	040	100)* s	Setup	Start Stop	171.	S1* S2*
Start Date: Required Date: Reference:	1/07/14 1/07/14	Start Qty: 80.00 Req'd Qty: 80.00	*80* *80*		Cust Item l Customer:	D:						
Approvals:	Process Pla	nn:	Date:	Tooling: SPC (Y/N):		ate:		F	Run	Start Stop	^IVI	R1* R2*
Sequence ID/ Work Center II)	Operation Description Identify as per dwg & Sto	ock Location: FP od	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
100 Packaging Packaging		Memo		0.00				_X &₹	(4 —	_YU_	<u>(dozler</u>

200

QC21- Final Inspection - Work Order Release

0.00

200

Memo

0.00

Quality Control

MLJ 14-02-05

DQA:			Date:										
						WORK ORDER NON	-CC	ONFO	RMANCE / U	PDATE			AEROSPACE
QA Closed:			Date:							W	ork Order up	date only	
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT,	PROCESS	
Part N	٠ ١٥٠					Rework Scrap Use-as-is			Skid-tube Machining noforming	Crosstube Small Fab Finishing	=	Water Jet d. Eng. Coor. e/Packaging	Engineering Quality Other
NCR N	۱o.					Suspected Unapproved]		Large Fab	Composite	<u> </u>	Supplier	
Root					Desci	ription of work order update	I	nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling													
Handling/Pre													
Material												i	
Operator													
Offset/Setup													
Process													
Supplier													!
Training													
Transport													
Unapproved							1						
							FA	ULT CA	TEGORY		-		
Landi	ng (Gear				General		_					_
		Bending				Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	ાં	Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/U	nqualified	Part Lost/Mi	ssing	Weld
		Cuffs				Contamination		Instruc	tions Incomplete/	Unclear	Part Moved		Wrong Stock Pulled
		Crushing				Countersink		Misali	gned/off center		Positioned V	Vrong	_
		Heat Trea	at			Cut Too Short		Mislab	eled		Power Loss/	Surge	Other
		Inspection	n Strip in	Tube		Drawing		Misrea	d				
		Marks/Ch	natter			Drill Holes		Off-set					
		Turning S	equence			Finish		Out of	Calibration				
		Wave/Tw	ist in Tub	эе		Fit/Function		Out of	Sequence				

January-07-14 3:08:49 PM

Work Order ID:

110821

Parent Item:

D3537-1

Parent Item Name:

Wearpad

Start Date: 1/07/14

Required Date: 1/07/14

Start Qty: 80.00

Required Qty: 80.00

Comments:

IPP Rev:A

New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA	, ,	Purchased	No			100	sf	330.8470	0.106	8 926312		1	
304/316 Sheet .063												1/c 1	14.01.
				Location		Loc Qty	<u>Lo</u>	c Code					
				MAT020		330.847							
				M126	5915	10.847						Δ	
				M127	7821	320			12	7821-	\rightarrow	9.6	ני

DQA:			Date:											•	TRAGE
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / U		Nork C	rdor u	odate only	_	AEROSPACE
QA Closed:			Date:		1					,	VOIR	raer u	date only		
Work Orde	er:					DISPOSITION				AGAINST (EPAR	TMENT,	/PROCESS		
	-					Rework			Skid-tube	Crosstube	7		Water Jet		Engineering
Part i	No.					Scrap			Machining	Small Fab	_	Pro	d. Eng. Coor.		Quality
	•				_	Use-as-is			noforming	Finishing	F		re/Packaging		Other
NCR I	No.					Suspected Unapproved			Large Fab	Composite			Supplier		
			·												
Root	ł				Desci	ription of work order update		nitial		ction		gn &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription	[ate	Verification	1	QC Inspector
Design															
Doc/Data															
Equip/Tooling			:												
Handling/Pre	Щ					!									
Material															
Operator															
Offset/Setup															
Process	Щ														
Supplier									İ						
Training											ł				
Transport	Щ														
Unapproved							<u> </u>								
							FAI	ULT CA	regory						
Landi	ng (1			Γ	General		1 /-		г	–		. г		l- <i>1</i>
	_	Bending			<u> </u>	Bend	<u> </u>	1 .	Program	}			nensions		Pressure/Forced
		Centre No	ot Concer	ntric	-	BOM/Route	<u> </u>	Grain		-			tolerance		Set-up
	_	Cracks			-	Broken/Damage/Defect		Hardwa			_	Incorre	F		Temperature/Cure
	<u> </u>	Crimp/Kir	nk/Ripple	/Wave	\vdash	Burrs	-	1	ion Incomplete/U		_	Lost/M			Weld
	<u> </u>	Cuffs			-	Contamination		4	tions Incomplete/	<u> </u>		Moved	L		Wrong Stock Pulled
	\vdash	Crushing			-	Countersink	_	4	gned/off center	}	_	tioned \	· · · · · ·		0.5
	-	Heat Trea		T b -	\vdash	Cut Too Short	\vdash	Mislabo		L	Pow	er Loss/	Surge [Other
	<u> </u>	Inspectio	-	rupe	-	Drawing	<u> </u>	Misrea							
	 	Marks/Ch			<u> </u>	Drill Holes	\vdash	Off-set					· · · · · · · · · · · · · · · · · · ·		
	\vdash	Turning S				Finish		4	Calibration		-				· · · ·
i	1	Wave/Tw	rist in Tub	oe -		Fit/Function	1	Out of	Sequence						

DART AEROSPACE LTD	Work Order: \	12801
Description: Wearpad	Part Number:	D3537-1
Inspection Dwg: D3537 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

					<i>,</i> .	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.250	+/-0.010	4.256			V	JKm-05
3.500	+/-0.010	3.500	_		V	
1.965	+/-0.010	1,968	_	-	V	
2.795	+/-0.010	2.795	-		V	
3.625	+/-0.010	3.625	_		V	
0.220 x 0.380	+/-0.010	218x.378	-		V	
			-			

Measured by:	Audited by:	DAS	Prototype Approval:	N/A
Date: 14.01.26	Date:	16 14/01/27	Date:	N/A
		9-89		

Rev	Date	Change	Revised by	Approved
Α	07.03.21	New Issue	KJ/JLM	
В	07.04.27	Dimensions revised per Dwg Rev. B	KJ/JLM	1
С	07.05.28	Dimensions revised per Dwg Rev. C	KJ/JLM	adl
			77	7/01/

